

# Work Order ID 69473

Tuesday, May 31, 2011 8:52:51 AM



Page 1

Item ID: D350-578-011

Revision ID:

Item Name: Bearpaw

Start Date: 5/11/2011 Start Qty: 6.00

Required Date: 5/18/2011 Req'd Qty: 6.00

Reference:

Approvals:

Process Plan:

Date:

QC:

Date:

Tooling:

Date:

SPC (Y/N):

Date:

Run Start

Stop

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

Draw Nbr

Revision Nbr

D2432

Rev F3

100

0.00



DC

Document Control

DOCUMENT CONTROL

Memo

0.00

Photocopy bluefile and create labels per PPP D350-578-011 CHG005

8/16/12

for BG 11-5-31 (4)

160

Pick Kit

0.00



Packaging

Packaging

Memo

0.00

11/6/11 SL (4)

170

QC4- 100% Inspect kits for completeness

0.00



QC

Quality Control

Memo

0.00

8/16/12

(+4)

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Item ID: D350-578-011

Accept



Setup Start



Revision ID:

Stop



Item Name: Bearpaw

Start Date: 5/11/2011 Start Qty: 6.00



Required Date: 5/18/2011 Req'd Qty: 6.00



Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID Tool # Plan Code Accept Qty Reject Qty Reject Number Insp. Stamp

180

0.00



Packaging

Packaging

Memo

0.00

Packaging

Identify and pack for shipping as per PPP D350-578-011. Location: \_\_\_\_\_ 11 RCO A

11/6/13 40 J

190

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/6/13 MF 11-06-03

# Picklist Print

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Work Order ID: 69473

Parent Item: D350-578-011

Parent Item Name: Bearpaw



Start Date: 5/11/2011

Required Date: 5/18/2011

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP Rev:A New Issue 07-01-02 JLM  
 IPP Rev:B 08-01-09 Added Step 2 JLM Verified By:EC  
 IPP Rev:C 08-10-15 New Manufacturing Method JLM Verified By:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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AN4-17A

Purchased

No

160

Each

614.0000

12

72



Bolt

Location

Loc Qty

Loc Code

ST358

300

~~116419~~

0

~~116704~~

0

~~117514~~

200

~~117619~~

100

ST359

314

~~116419~~

14

~~116704~~

300

D2182B

Manufactured

No

160

f

270.9548

2.5

15



Rubber Cushion

Location

Loc Qty

Loc Code

ST410

270.95477

~~66063~~

270.95477

Cut qty 6 at 5.00" long

14

11/6/2011

# 51

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

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Work Order ID: 69473

Parent Item: D350-578-011

Parent Item Name: Bearpaw

Start Date: 5/11/2011

Required Date: 5/18/2011

Start Qty: 6.00

Required Qty: 6.00



Radius Block

Manufactured No

160 Each

651.0000 12 72



*[Handwritten signature]*

## Location

## Loc Qty

## Loc Code

ST010 651  
 59108 12  
~~62658~~ 36  
~~65562~~ 20  
 67578 44  
~~68937~~ 4  
 68942 235  
 69736 200  
 69773 100

*[Handwritten notes: 12, 72, 20, 44, 4, 235, 200, 100]*



206 (24") Bearpaw

Manufactured No

160 Each

0.0000 2 12



*[Handwritten: 68672]*

*[Handwritten signature]*



Clamp

Manufactured No

160 Each

236.0000 6 36



*[Handwritten signature]*

## Location

## Loc Qty

## Loc Code

ST456 236  
 67830 47  
~~68673~~ 81  
 69737 108

*[Handwritten: 24]*



Washer

Manufactured No

160 Each

399.0000 12 72



*[Handwritten: 11/6/11]*

## Location

## Loc Qty

## Loc Code

ST016 399  
 66953 399

*[Handwritten: 48]*

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Shop Packet Print

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

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Parent Item: D350-578-011

Parent Item Name: Bearpaw

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Start Date: 5/11/2011

Required Date: 5/18/2011

Start Qty: 6.00

Required Qty: 6.00

MS21042L4

Purchased

No

160

Each

4,431.000

12

72



Nut

## Location

## Loc Qty

## Loc Code

ST300

4431

116823

631

117441

3000

117601

800



2/8

NAS1149D0463J

Purchased

No

160

Each

3,635.000

24

144



Washer

## Location

## Loc Qty

## Loc Code

FP-B

8

116805

8

ST298

3627

116025

26

116805

0

117291

1001

117460

1600

117591

1000



2

7/6

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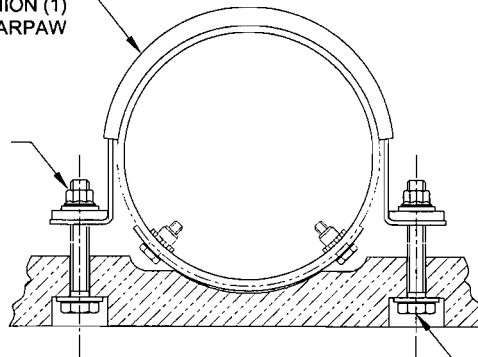




**REFERENCE ONLY**

D2438 CLAMP (1)  
D2182B050 RUBBER CUSHION (1)  
3 PL PER BEARPAW

MS21042L4 NUT (1)  
AN960JD416 WASHER (1)  
D2274 RADIUS BLOCK (1)  
D2529 WASHER (1)  
AN4-17A BOLT (1)  
6 PL PER BEARPAW



ADDITIONAL AN960JD416 WASHERS MAY BE INSTALLED UNDER THE NUTS TO ENSURE 1.5-4 THREADS IN SAFETY ON THE BOLTS. ALTHOUGH NOT GENERALLY NECESSARY, IT IS ALSO ACCEPTABLE TO REPLACE THE AN4 BOLTS PROVIDED WITH LONGER OR SHORTER AN4 BOLTS, IF REQUIRED.

**Section A-A****Figure 4 – Clamping Detail****5.0 PARTS LIST**

Qty -011	Qty -021	Part Number	Description
X		D350-578-011	BEARPAW INSTALLATION
	X	D350-578-021	BEARPAW INSTALLATION
6	6	D2182B050	Rubber Cushion
12	12	D2274	Radius Block
12	12	D2529	Washer
6	6	D2438	Clamp
2		D2432F	Bearpaw
	2	D2672F	Bearpaw
12	12	AN4-17A	Bolt
24	24	AN960JD416	Washer
12	12	MS21042L4	Nut (or MS21042-4)

